

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004045**Date Inspected:** 28-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Fabrication**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

CWI Inspector: Mr. Sun Wei

Heavy Bay #3:

ZPMC QC Inspector Mr. Sun Wei informed the QA Inspector that he and ABF Inspectors are performing final visual inspections of the welds of deck panel DP589-001 and DP571-001 in heavy bay #3 and they are ready for QA visual inspections. The QA Inspector marked a few additional areas of weld overlap and ZPMC workers blended the overlap with an electric grinder. The QA Inspector documented the final visual inspection on the yellow inspection status tag that is attached to the deck panel.

ZPMC informed the QA Inspector that ZPMC Inspector Mr. Yi Yan hua and ABF Inspector Mr. Ding are performing initial visual inspection of the welds of deck panel DP563-001 in heavy bay #3 and they are ready for QA visual inspections. The QA Inspector marked a few additional areas of weld overlap and QA Inspector documented the initial visual inspections on the yellow inspection status tag that is attached to the deck panel.

Bay 7

WELDING INSPECTION REPORT

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ZPMC notification of witness inspection document #00929 dated 8-28-2008 states that ZPMC QC inspection personnel will be conducting final ultrasonic inspections of floor beam FB019-001 welds in bay #7. Around 1530 hours the QA Inspector performed ultrasonic inspection of approximately 10% length of floor beam FB019-001 welds -78, -79, -80, -81, -101, -108, -117, -122, -125, -126 and -127 and items appear to comply with project specifications. Each of these welds had been identified by ZPMC inspection personnel as being UT accepted earlier today. See the TL6027 ultrasonic test report for additional information.

Bay 1

ZPMC notification of witness inspection document #00929 dated 8-28-2008 states that ZPMC QC inspection personnel will be conducting final ultrasonic inspections of deck plate DP362-001 closed rib CJP splice welds in bay #1 today. The QA Inspector performed ultrasonic inspection of closed rib CJP butt welds DP362-001-190, -192 and -193 and items observed appear to comply with project specifications. Each of these welds had been identified by ZPMC inspection personnel as being UT accepted earlier today. See the TL6027 ultrasonic test report for additional information.



Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
